

Date: Monday, 12/01/2009 2:36:36 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARSHOE
Job Number :	44645		
Estimate Number :	12729		
P.O. Number :		Part Number :	D353539
This Issue :	12/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3535 REV B
First Issue :	//	Project Number :	N/A
Previous Run :	42328	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	JLD 09.01.13	Due Date :	30/01/2009
Comment :	Est Rev:A New Issue 07-02-15 JLM	Qty:	12
	Est Rev:B As per Rev B 07-08-31 JLM	Um:	Each
	Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.9986 sf(s)/Unit Total : 11.9826 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: 110076 HB 9-2-2

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: B

Prog Rev: B

HB 9-2-2

(13)

2-Deburr if necessary

HB 9-2-2

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



HB 9-2-2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

502102102 (13)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------

**Comment:** NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.

Identify as D3535-41

SB 09/02/03 (13)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:36:36 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 44645

Part Number: D353539

Job Number:



Seq. #:

Machine Or Operation:

Description :

Form Joggle on brake using Jig DT8158 as per Dwg D3535

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sp 09/02/03 (13)

7.0

POWDER COATING

POWDER COATING



m109648



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

3:10

OVEN TEMPERATURE:

320°

FINISH TIME:

3:40

FL 09/02/03 (13)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT

04-06-03

(X13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FL-18

FL 09/02/04 (13)

10.0

QC21

- FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/04

Job Completion



U 09.02.04

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>W11045</u>
Description: Wearshoe		Part Number: D3535-39
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.815	x			
32.775	+/-0.010	32.775	x			
29.275	+/-0.010	29.275	x			
25.775	+/-0.010	25.775	x			
23.250	+/-0.010	23.250	x			
19.750	+/-0.010	19.750	x			
17.750	+/-0.010	17.750	x			
14.250	+/-0.010	14.250	x			
9.500	+/-0.010	9.500	x			
4.750	+/-0.010	4.754	x			
2.000	+/-0.010	2.002	x			
5.00	+/-0.030	5.001	x			
9.00	+/-0.030	9.00	x			
28.00	+/-0.030	28.00	x			
Ø0.188	+0.005/-0.001	.190	x			
1.885	+/-0.010	1.886	x			
0.300	+/-0.010	.307	x			
0.300	+/-0.010	.306	x			
0.038	+/-0.010	.040	x			

Measured by: <u>B</u>
Date: <u>9-2-2</u>

Audited by: <u>S</u>
Date: <u>09/02/02</u>

Prototype Approval:	N/A
Date:	N/A

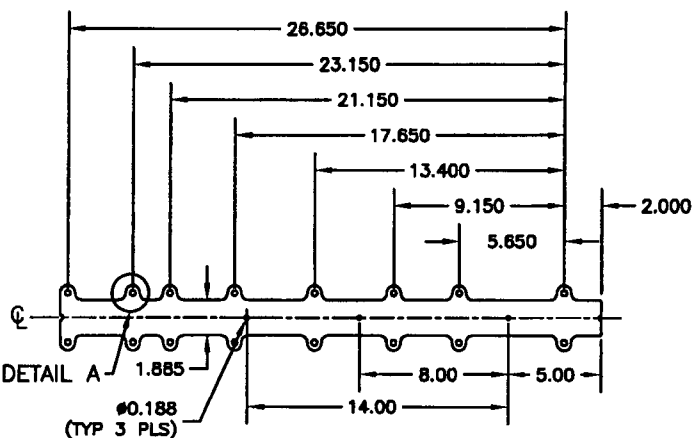
Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM <u>A</u>	<u>B</u>

DART

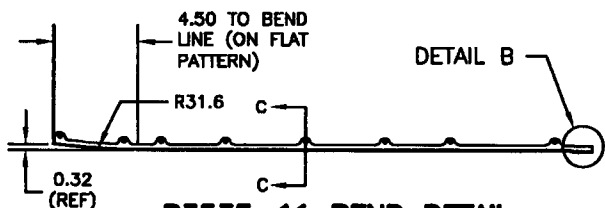
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PH	PH	D3535
DATE	TITLE	SCALE
07.04.17	WEARSHOE	1:10
REV	DATE	DESCRIPTION
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

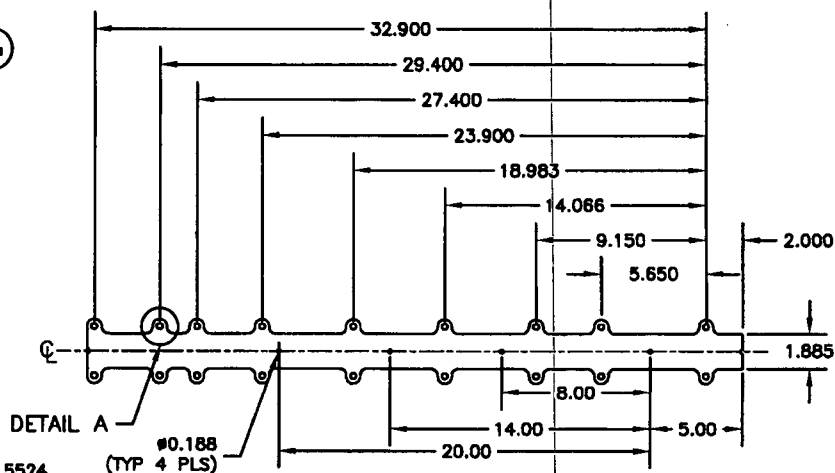


D3535-11F FLAT PATTERN

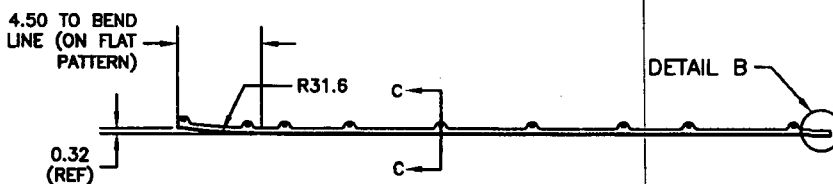


D3535-11 BEND DETAIL

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D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

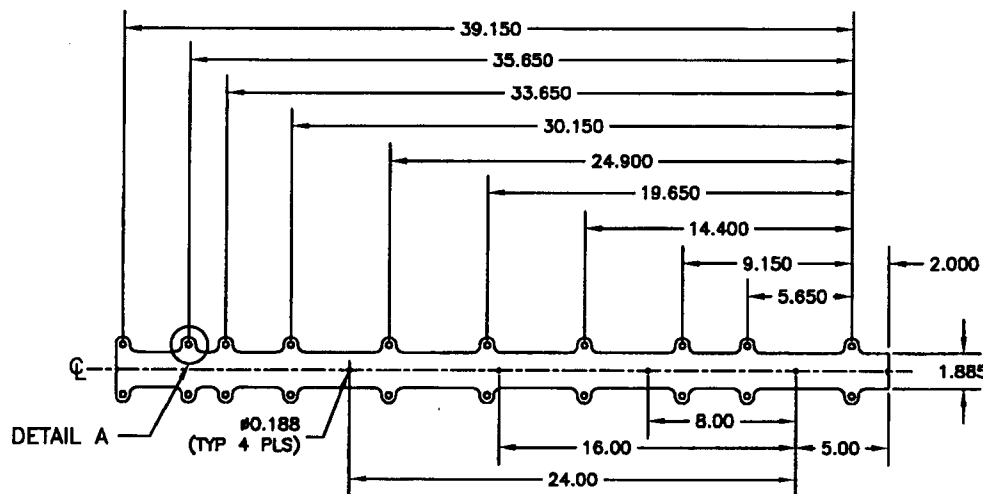
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- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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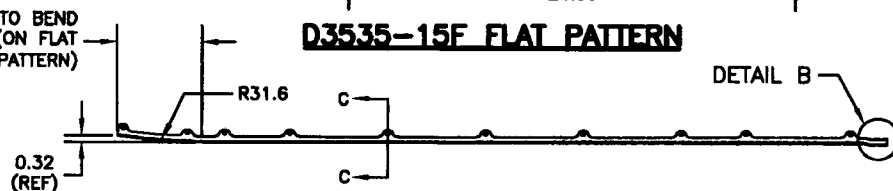
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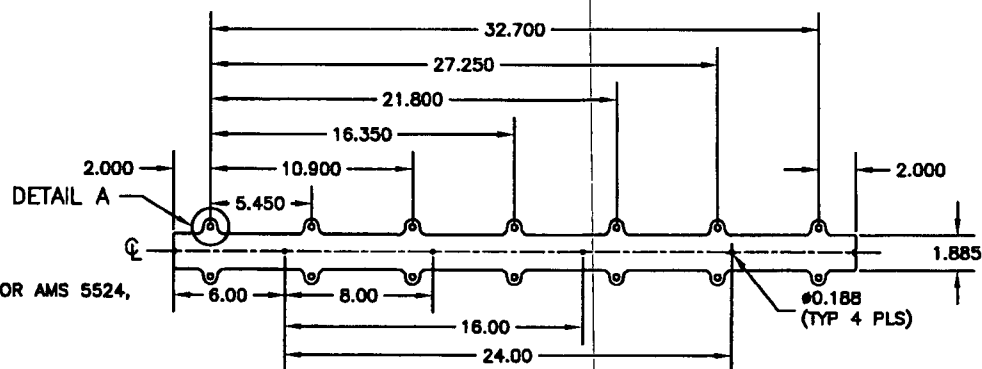
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#	#	D3535
DATE	TITLE	SHEET 2 OF 7
07.04.17	WEARSHOE	SCALE
		1:10



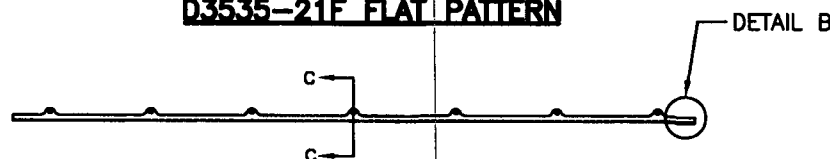
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

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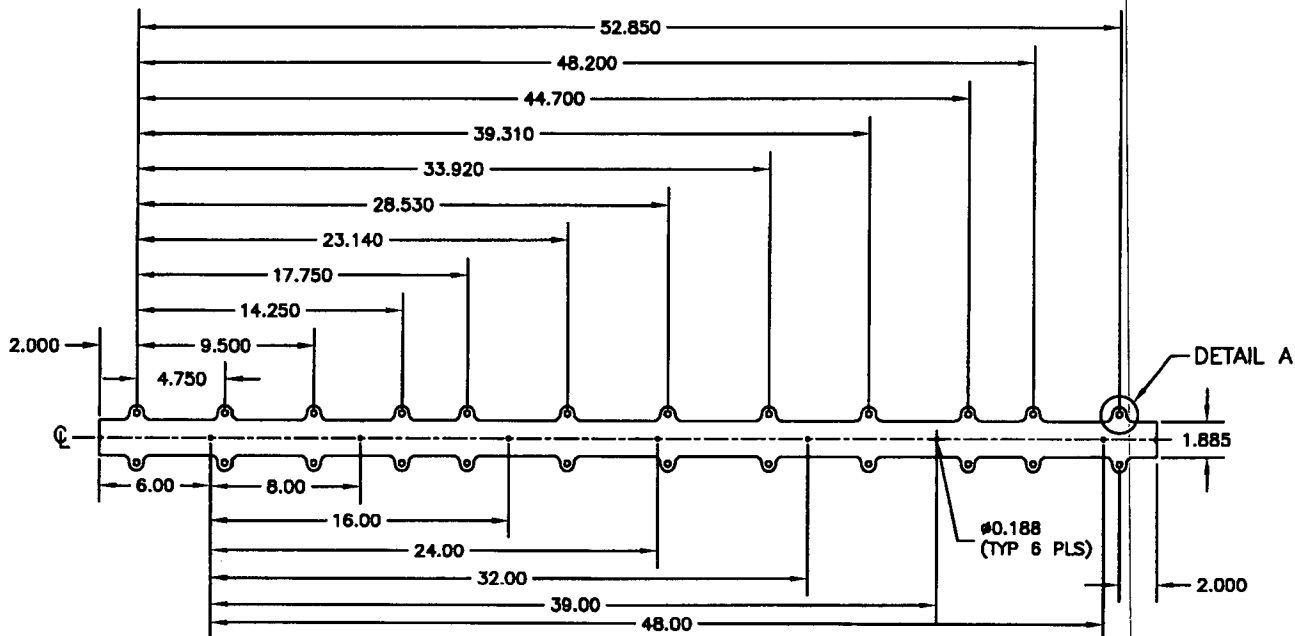
NOTES

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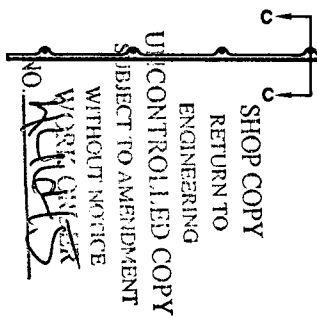
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DATE 07.04.17		TITLE WEARSHOE	SCALE 1:10

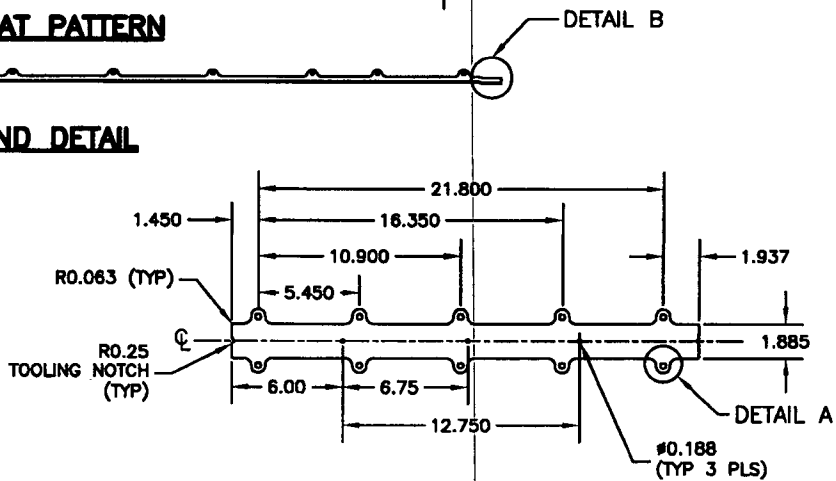
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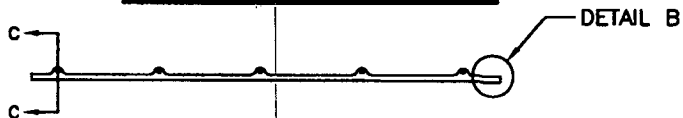
D3535-23F FLAT PATTERN



D35.35-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
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QSI 005 4.3
 - 3) PART IS SYMMETRICAL ABOUT ϕ
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS
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 - 5) ALL DIMENSIONS ARE IN INCHES
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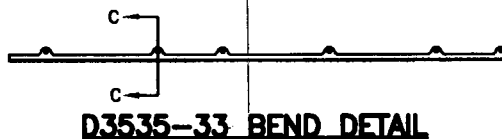
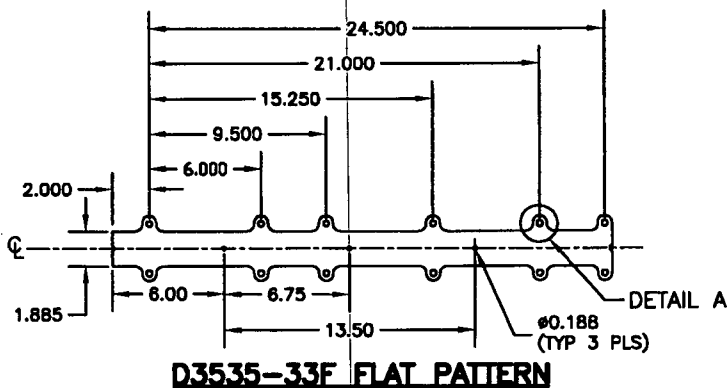
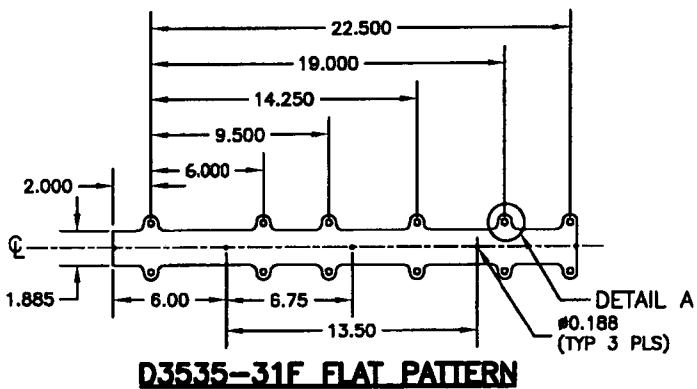
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		SCALE			1:10



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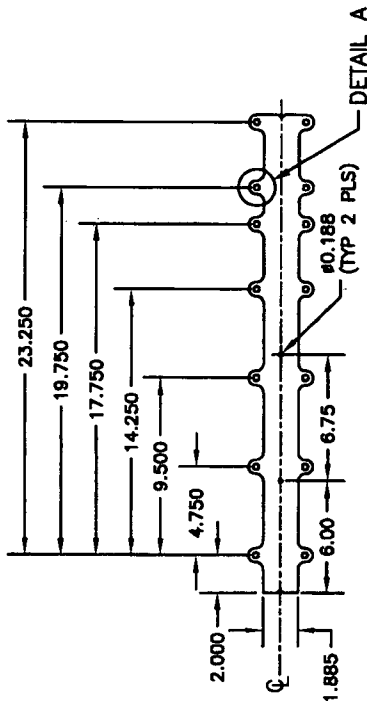
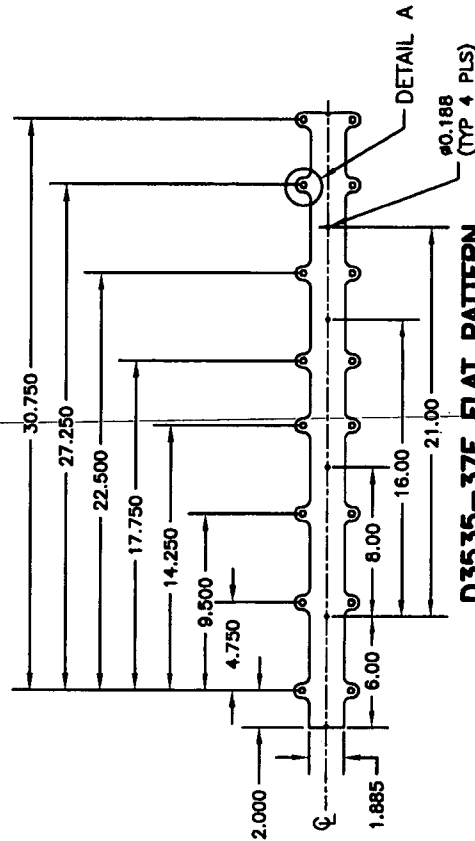
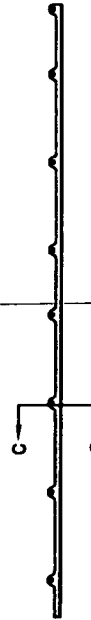
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**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

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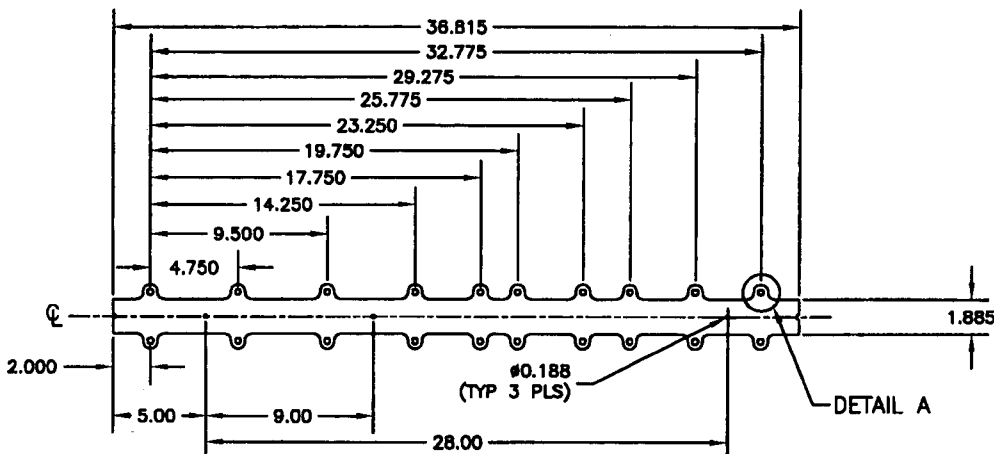
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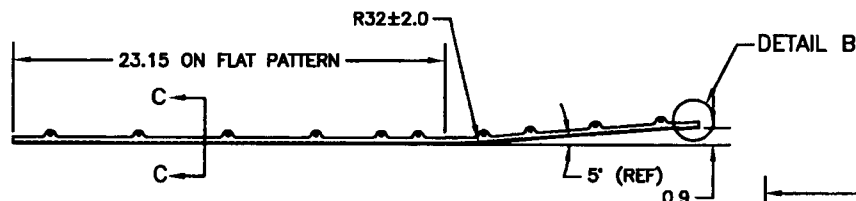
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DATE 07.04.17	TITLE WEARSHOE	SCALE 1:10	



D3535-39F FLAT PATTERN

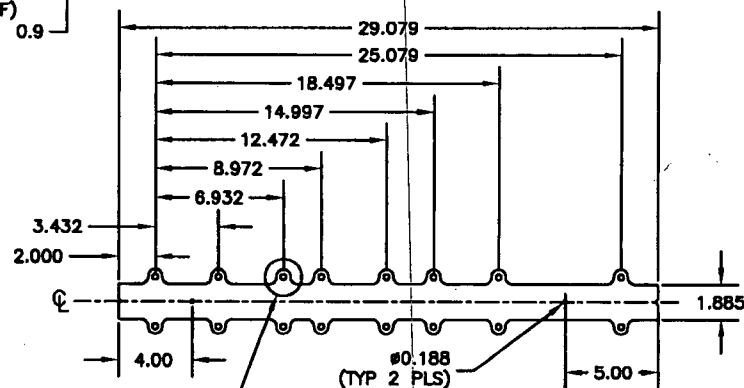


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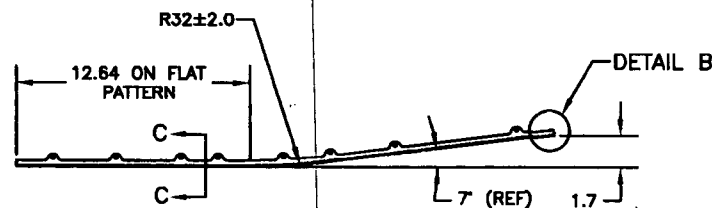
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NOTES

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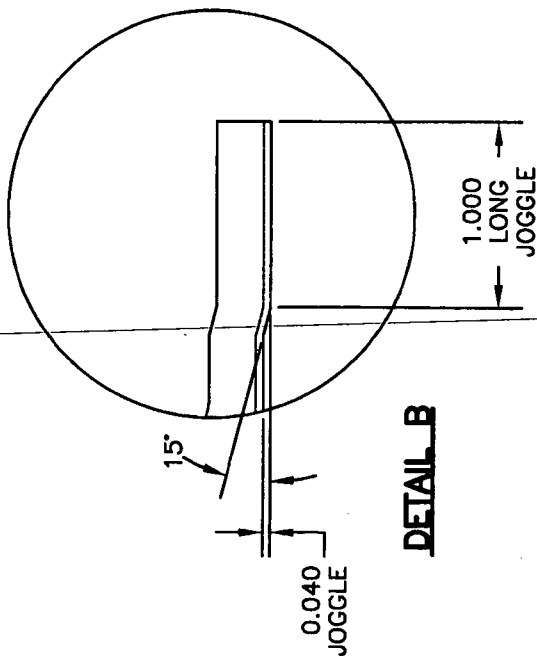
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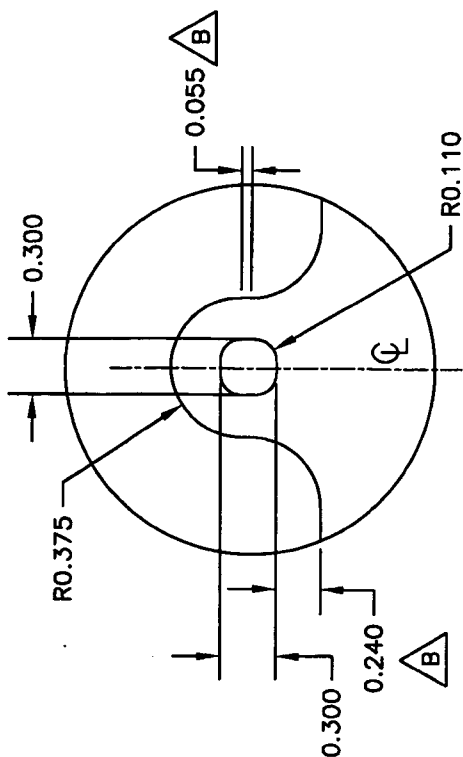
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DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

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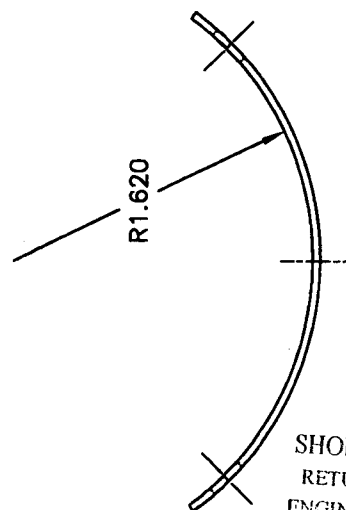
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DETAIL B



DETAIL A



SECTION C-C

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